

Date: Wednesday, 06/08/2008 2:07:47 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	350 SKIDTUBE ASSEMBLY RH
Job Number :	41036		
Estimate Number :	10265		
P.O. Number :		Part Number :	D350636012
This Issue :	06/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2750 UNDER REVIEW
First Issue :	//	Project Number :	N/A
Previous Run :	40702	Drawing Revision :	
Written By :		Material :	
Checked & Approved By :	JLD 08.8.06	Due Date :	13/08/2008
Comment :	Est Rev:I 02.09.25 Rearranged procedure steps KJ Est Rev:J 06-03-29 As per Rev D EC Est Rev:K 06-07.13 As per dsi9343 EC Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC Est Rev:M 08-04-22 update steps 4,13 DD verified by:EC		

PA 06.08.12
UPDATE PER
DSI 9413

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.8.13



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

2.0	D26003BENT	Extrusion Bent
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

41122

SL 8-8-26

3.0	D2744	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

39242

SL 8-8-26

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 41036

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for Detail G using DT8329

5-Open up holes for Detail B to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750. Open holes for ground handling and detail E to 0.500" (8 holes per side)

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108

****Make sure that wearplate holes are on bottom of tube*****

Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297".

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R

Aluminum Rod

m/108096/m/107877

BE 8-8-26

10-Grind welds flush as per Dwg D2750

SL 8-8-26

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 8-8-26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch:

41127

RT 08-09-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	D34901	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

B 39584

RE

08/09/05

11.0	D34903	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

B 40727 (3)

B 41136 (1)

RE 08/09/05

12.0	D2743	Crossbolt Spacer
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch:

B 40725

RE 08/09/05

13.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail B, E, ground handling and float holes per dwg D2750 (welding instructions on
sheet 4)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

108801

exp. date:

8-10-01

RT 08-09-04

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 4)

J08-9.3

W/O:		WORK ORDER CHANGES					
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Job Number: 41036

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Aluminum Rod batch: M108708 BE 08/09/05

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

11-Deburr holes

Handwritten: - HWM
- 8-9-8

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Handwritten: 08.09.190



Handwritten: (Pb) →

Comment: VISUAL INSPECTION OF GROUND WELDS

15.0

QC5

INSPECT WORK TO CURRENT STEP



Handwritten: 08.09.190



Comment: INSPECT WORK TO CURRENT STEP

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Handwritten: (IX)

Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

Handwritten: M-A 08/09/19

17.0

POWDER COATING

POWDER COATING



Handwritten: M108523



Handwritten: (IX)

Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Handwritten:
11:15
320°F
11:45

Handwritten: M-A 08/09/19

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Handwritten: HD



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

Handwritten: 08-09-23 (X)

19.0

ALS41032225

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

Insert

Batch: M100621

Handwritten: M 08.09-23 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-012 PAR #: N/A Fault Category: Prod / Skidhibe NCR: (Yes) No DQA: D Date: 08/09/18
 QA: N/C Closed: D Date: 08/09/18

NCR: <u>41036</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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8/9/18	13.10	During inspection it was found that all 8 spot faces were Done too Deep and off to one side	<u>Q51042</u>	Re weld all 8 Spot faces <u>As m108708</u> as per AS7004	<u>B.F.</u> <u>08/09/17</u>	<u>106-09-19</u>	<u>Q51042</u>	<u>S</u> <u>glab</u>
		R.C operator / Human Error Also the pilot on the spot face was too small in Dia.	<u>Q51042</u>	Grind welds flush and re spot face as per Dwg. - Train all dept employees on how to spot face & get a new pilot.	<u>AWM</u> <u>8-9-18</u>	<u>106-09-19</u>	<u>Q51042</u>	<u>S</u> <u>glab</u>

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Job Number: 41036

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
1-Install inserts as per dwg D2750

Handwritten: 08-09-23 (X1)

21.0	D2745	Bushing
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bushing
Batch: (X5) -> B336230 (X3) -> B41114

22.0	D353525	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B39716

23.0	D353625	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: B410729

24.0	D35371	Wearpad
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
WEARPAD
Batch: B411082

25.0	D37911	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate
Batch: B39694

26.0	D37931	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearshoe
Batch: B410551

Handwritten: 08-09-23 (X1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Job Number: 41036

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	D37933	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Wearshoe B40552 *HL*

28.0	D37941	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Gasket B40553 *HL*

29.0	D37943	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Gasket B39713 *HL*

30.0	D36721	Phenolic Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
Phenolic Washer B39275 *HL*

31.0	AN526C1032R10	Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Screw M108062 *HL*

32.0	AN526C1032R18	Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Screw M4523 *HL*

33.0	D36311	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
WASHER
Batch: B41141 *HL*

34.0	D3488042	Blade Fitting Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Blade Fitting, RH
Batch: B38787 *HL*

08-09-23

(X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41036

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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35.0	D3492041	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B41137 *JA*

36.0	D3492043	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: (2x) B40728 (6x) B41138 *JA*

37.0	AN3C5A	Bolt
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Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

Batch: M108928 *JA*

38.0	AN3C6A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M105300 *JA*

39.0	AN6C44A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M109091 *JA*

40.0	AN8C35A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M106896 *JA*

41.0	AN960C10L	washer
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: M108928 *JA*

08.09-23 (X)

W/O:		WORK ORDER CHANGES					
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Process Sheet

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41036

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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42.0	AN960C816L	WASHER
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1 PH 08.06.12



Comment: Qty.: 20000 Each(s)/Unit Total: 20000 Each(s)

WASHER

Batch: M108928

PH

43.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: M108857

PH

44.0	MS21083C8	NUT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: M108880

PH

45.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Batch: M108964

PH

46.0	NAS1515H8L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch:

NOT REQ'D
PH 08.08.12

47.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

Batch: M107912

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M108801

EXP DATE: 08/10

PH 08.08.23 XQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Coat all exposed fasteners with "LPS Procyon"

batch: M104251

08-09-23

(41)

48.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/08/25 40

49.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

50.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: P240724

sf

51.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M108926

sf

52.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M108880

sf

53.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M109042

sf

54.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M101581

8/9/25

(1x)

SO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 41036

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: B40829

56.0

D35321

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

spacer

Batch: B38594

57.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

58.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

CHG 004 PH 05.06.12 flew G

59.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-26

B41036

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. E SHEET 1 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS	
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3 / D2750-4; INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133 / 9157	
E	07.05.17	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY(38) NAS1515H3L; REMOVE QTY(10) NAS1515H8L; REMOVE D2741, QTY(2) AN960C816; REMOVE QTY(2) MS21083C8	

RELEASED
07.08.02

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-13	WEARSHOE
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3535-35	WEARSHOE
1	1	1	1	D3536-13	GASKET
1	1	1	1	D3536-25	GASKET
1	1	1	1	D3536-35	GASKET
5	5	5	5	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
42	42	42	42	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
2	2	2	2	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER
2	2	2	2	NAS1515H8L	WASHER

07.08.12
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DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

GENERAL NOTES:**RELEASED**
07-08-02 *[Signature]*

1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ($\emptyset 0.297$) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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DART SERVICE INSTRUCTION

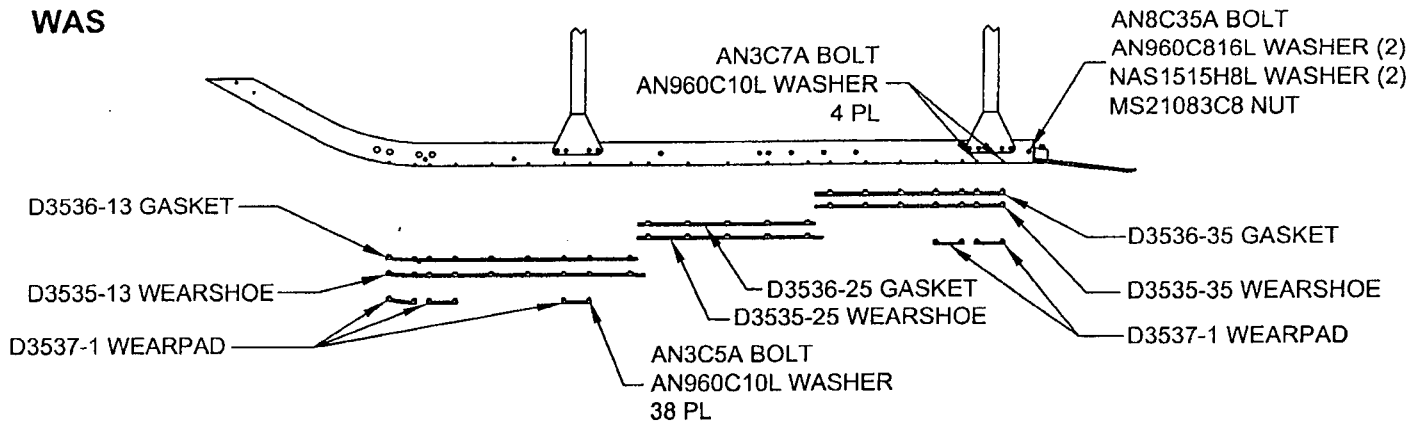
TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV E

REF FAA STC: SR00646SE

REF CANADIAN STC: SH99-7

THE WEARPLATES ON D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 (AND LATER) HAVE BEEN MODIFIED AS SHOWN IN FIGURE 1 BELOW TO ELIMINATE THE POSSIBILITY OF INTERFERENCE BETWEEN THE WEARPLATES AND CROSSTUBE SADDLES AT INSTALLATION. THERE IS NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

WAS



NOW

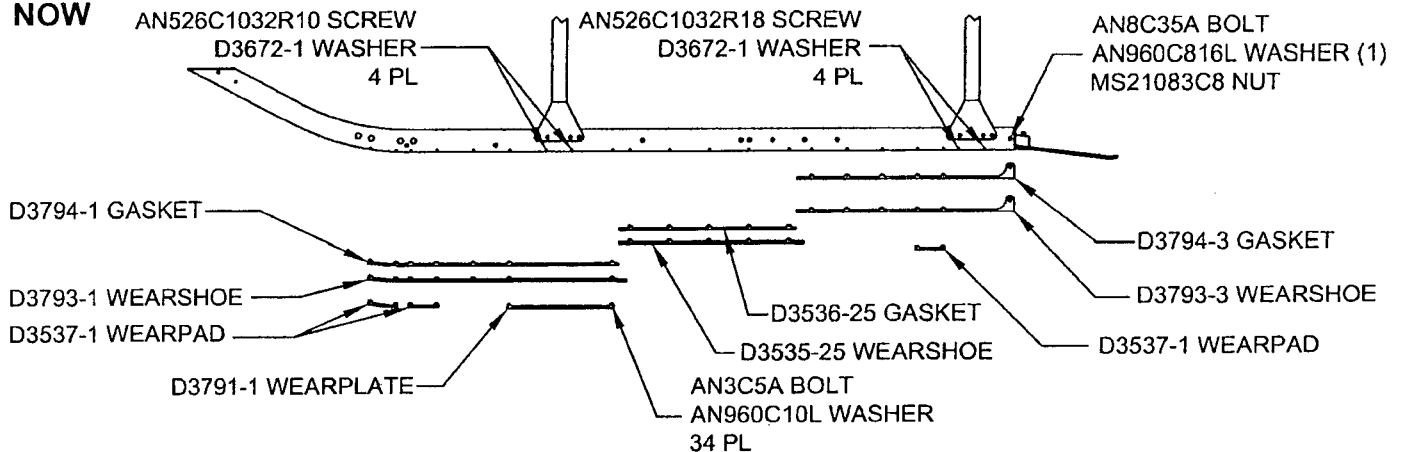


FIGURE 1 - WEARPLATE MODIFICATION

(AN526C1032RXX SCREW LOCATIONS NO LONGER USED TO MOUNT WEARSHOES)

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A	NEW ISSUE	PH	08.05.14
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DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9413	SHEET 1 OF 3
APPROVED	H	TITLE	SCALE
DE APPR.	H	WEARSHOE MODIFICATION	NTS
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FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004, AMEND PARTS LIST OF IIN-D350-636 SECTION 5 AS FOLLOWS:

REMOVE:

Item	Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
	X				D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X			D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X		D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X	D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
*6A	1	1	1	1	AN960C816L	WASHER
6B	2	2	2	2	NAS1515H8L	WASHER
*22	2	2	2	2	D3537-1	WEARPAD
23A	1	1	1	1	D3535-13	WEARSHOE
23B	1	1	1	1	D3536-13	GASKET
25A	1	1	1	1	D3535-35	WEARSHOE
25B	1	1	1	1	D3536-35	GASKET
*26A	4	4	4	4	AN3C5A	BOLT
*26B	4	4	4	4	AN3C7A	BOLT
*27	8	8	8	8	AN960C10L	WASHER

*SUBTRACT FROM TOTAL QUANTITY OF PARTS INDICATED IN INSTALLATION INSTRUCTIONS IIN-D350-636

ADD:

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
X				D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
	X			D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X		D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
			X	D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
8	8	8	8	D3672-1	WASHER
4	4	4	4	AN526C1032R10	SCREW
4	4	4	4	AN526C1032R18	SCREW

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TO IMPROVE THE INSTALLATION OF D350-636-011/-012/-013/-014 SKIDTUBES EQUIPPED WITH STAINLESS WEARPLATES/WEARPADS AND GASKETS (CHG 003) ONTO THE CROSSTUBES, THE FOLLOWING DSI 9413-011 WEARSHOE KIT CAN BE PROCURED FROM DART:

Qty -011	Part Number	Description
X	DSI 9413-011	WEARSHOE MODIFICATION KIT
1	D3791-1	WEARPLATE
1	D3793-1	WEARSHOE
1	D3793-3	WEARSHOE
1	D3794-1	GASKET
1	D3794-3	GASKET
8	D3672-1	WASHER
4	AN526C1032R10	SCREW
4	AN526C1032R18	SCREW

TO INSTALL THE DSI 9413-011 KIT, REMOVE THE EXISTING WEARSHOES/GASKETS UNDER THE FWD/AFT SADDLES AND INSTALL NEW WEARSHOES/GASKETS AS SHOWN IN FIGURE 1. PLUG UNUSED HOLES WITH AN526C1032RXX SCREWS AND D3672-1 WASHERS. INSTALL SCREWS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT AS SHOWN IN FIGURE 1. **NOTE:** SOME OF THE PREVIOUSLY INSTALLED HARDWARE IS NO LONGER REQUIRED.

THE FOLLOWING D350-636-045 REPLACEMENT WEARPLATE KIT WILL BE AVAILABLE FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 OR LATER:

Qty -011	Part Number	Description
X	D350-636-045	WEARSHOE KIT
3	D3537-1	WEARPAD
1	D3535-25	WEARSHOE
1	D3536-25	GASKET
1	D3791-1	WEARPLATE
1	D3793-1	WEARSHOE
1	D3793-3	WEARSHOE
1	D3794-1	GASKET
1	D3794-3	GASKET
34	AN3C5A	BOLT
34	AN960C10L	WASHER

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NO. 168

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 41099
Part number: D350 636 012
Description: 350 skid
Welding Process: Tig[☒] Mig[]
Base materiel: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[]
pass[☒] fail[]

Penetration:

UNACCEPTABLE

Cracks:

pass[☒] fail[]

Undercut:

pass[☒] fail[]

Pin holes:

pass[☒] fail[]

Overlap (cold lap)

pass[☒] fail[]

Porosity (surface):

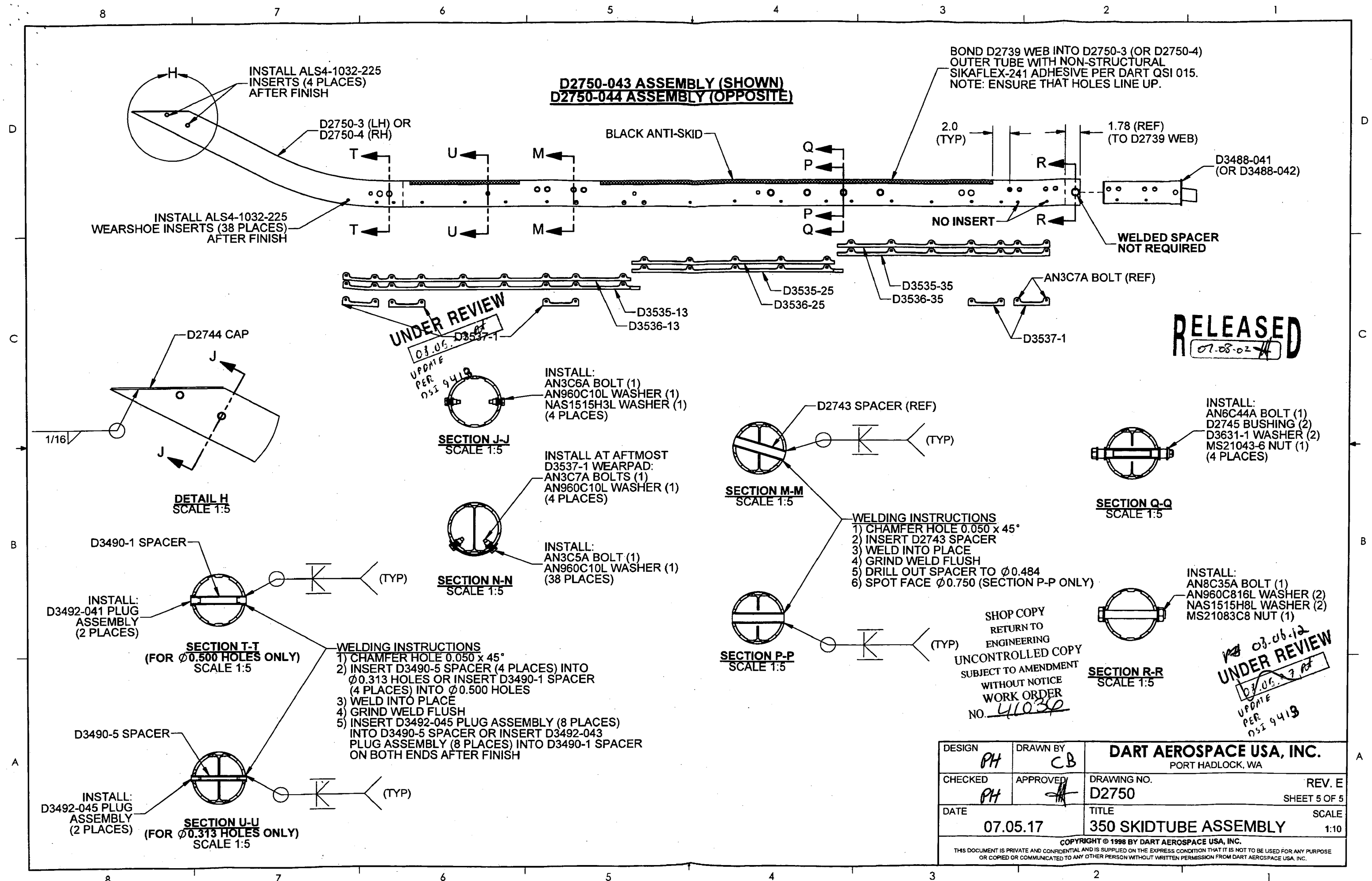
pass[☒] fail[]


Coloration:

pass[☒] fail[]

Qualifier Rob Paul Date of Test Coupon 08-08-21
Welder Barday Elliott Date of Test Coupon 08-08-21

The above named individual is qualified in accordance with AWS D17.1.2001 to weld



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INSTALL ALS4-1032-225
INSERTS (4 PLACES)
AFTER FINISH

**D2750-041 ASSEMBLY (SHOWN)
D2750-042 ASSEMBLY (OPPOSITE)**

BOND D2739 WEB INTO D2750-1 (OR D2750-2)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

INSTALL ALS4-1032-225
WEARSHOE INSERTS (38 PLACES)
AFTER FINISH

D2750-1 (LH) OR
D2750-2 (RH)

BLACK ANTI-SKID

2.0
(TYP)

1.78 (REF)
(TO D2739 WEB)

D3488-041
(OR D3488-042)

NO INSERT

WELDED SPACER
NOT REQUIRED

D3535-35
D3536-35

AN3C7A BOLT (REF)

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07.05.17

UPDATE PER
DSI 9413
REV 03.03.12

INSTALL:
AN3C6A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(4 PLACES)

SECTION J-J
SCALE 1:5

INSTALL AT AFTMOST
D3537-1 WEARPAD:
AN3C7A BOLTS (1)
AN960C10L WASHER (1)
(4 PLACES)

SECTION N-N
SCALE 1:5

INSTALL:
AN3C5A BOLT (1)
AN960C10L WASHER (1)
(38 PLACES)

SECTION M-M
SCALE 1:5

SECTION P-P
SCALE 1:5

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 x 45°
2) INSERT D2743 SPACER
3) WELD INTO PLACE
4) GRIND WELD FLUSH
5) DRILL OUT SPACER TO Ø0.484
6) SPOT FACE Ø0.750 (SECTION P-P ONLY)

INSTALL:
AN6C44A BOLT (1)
D2745 BUSHING (2)
D3631-1 WASHER (2)
MS21043-6 NUT (1)
(4 PLACES)

SECTION Q-Q
SCALE 1:5

INSTALL:
AN8C35A BOLT (1)
AN960C816L WASHER (2)
NAS1515H8L WASHER (2)
MS21083C8 NUT (1)


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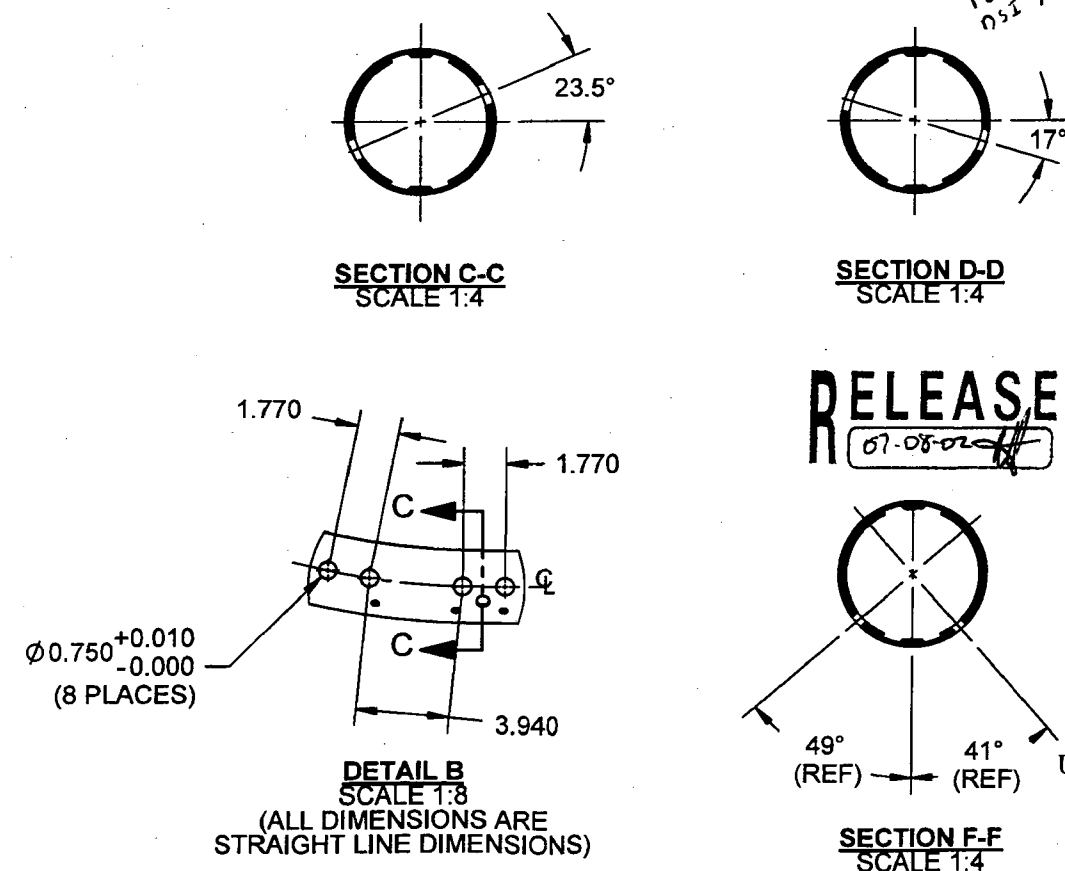
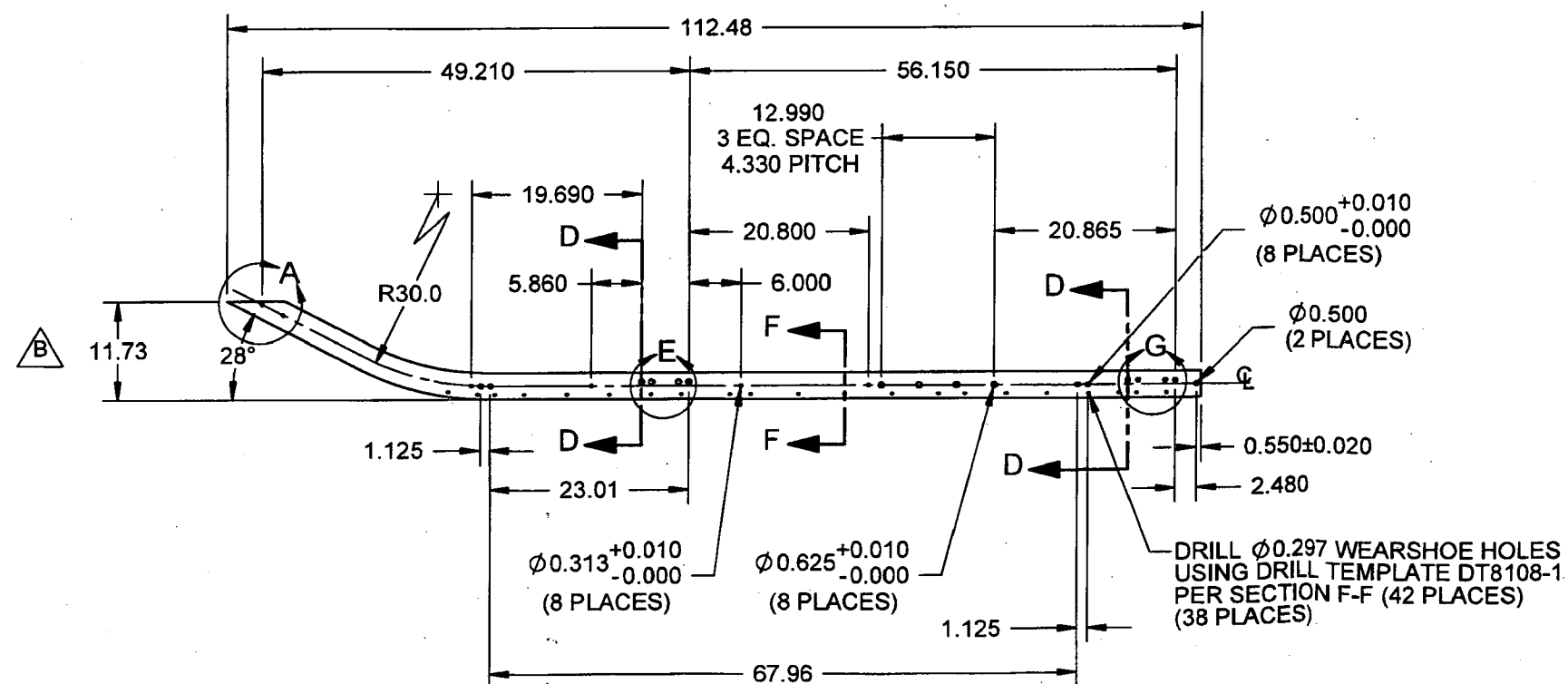
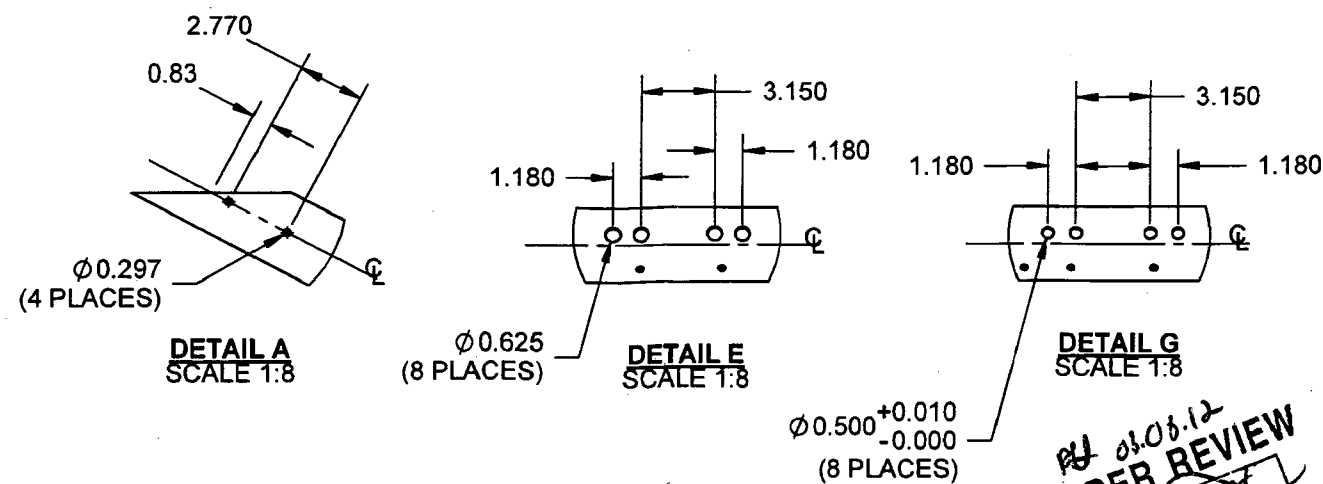
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SECTION K-K
(FOR Ø0.750 HOLES ONLY)
SCALE 1:5

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 x 45°
2) INSERT D3490-1 SPACER (4 PLACES) INTO
Ø0.500 HOLES OR INSERT D3490-3 SPACER
(4 PLACES) INTO Ø0.750 HOLES
3) WELD INTO PLACE
4) GRIND WELD FLUSH
5) INSERT D3492-041 PLUG ASSEMBLY (8 PLACES)
INTO D3490-1 SPACER OR INSERT D3492-043
PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER
ON BOTH ENDS AFTER FINISH

SECTION L-L
(FOR Ø0.500 HOLES ONLY)
SCALE 1:5

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